

Work Order ID 52371

Friday, September 25, 2009 10:58:57 AM



Page 1

Item ID: D3137-045

Accept



Setup Start



Revision ID: F

Stop



Item Name: Bracket Assembly

Start Date: 9/23/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan: *RL*

Date: *09-25*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3137	Rev F								

100



BAND SAW

0.00

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: (.500" x 2.000") 4.400" long

OK 09/10/04

4 0

110



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine D3137-9 as per Folio FA621 and Dwg D3137 Identify as D3137-9
9□2-Deburr□3-Scribe batch number

mtf 09/10/07

4 0

120



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

mtf 09/10/07

4 0

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Page 2

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Item Name: Bracket Assembly

Start Date: 9/23/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

a. Log 10/02

4 0

Quality Control

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Assemble D3137-045 as per Dwg D3137

E 509/10/07 (4)

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

2) S 07/10/07

(44)

Quality Control

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Setup Start



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Item Name: Bracket Assembly

Start Date: 9/23/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: *CA*

0.00



Packaging

Memo

0.00

u 09-10-07

Packaging

170

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

09/10/07

Quality Control

u 09-10-07

Picklist Print

Friday, September 25, 2009 10:58:57 AM

Page 1

Work Order ID: 52371

Parent Item: D3137-045RevF

Parent Item Name: Bracket Assembly

Comments:

Start Date: 9/23/2009

Required Date: 10/9/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS24694-S101

Purchased

No

100

Each

104.0000

4.0000



Screw

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

104

103338

5

110363

99

D3137-3RevF

Manufactured

No

140

Each

23.0000

4.0000



Guide

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

23

39449

9

39628

14

D3137-5RevF

Manufactured

No

140

Each

41.0000

4.0000



Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

41

10536

1

24547

2

42270

6

46740

32

9/29/10/07

9/29/10/07

9/29/10/07

Picklist Print

Page 2

Friday, September 25, 2009 10:58:57 AM

Work Order ID: 52371



Parent Item: D3137-045RevF



Parent Item Name: Bracket Assembly

Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M174B0.500X02.000		Purchased	No			140	f	84.7800	1.5436			
17-4 SS Bar .500 x 2.00												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

84.78

100843

13.01

103089

20.25

14932

26.63

19572

24.89

1.5436

SL 09/10/09

Friday, September 25, 2009 10:58:57 AM

Shop Packet Print

Page 2

DART AEROSPACE LTD		Work Order:	52371
Description: Bracket		Part Number:	D3137-9
Inspection Dwg: D3137 Rev: F		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.435	+/-0.010	.436	✓			
0.615	+/-0.010	.620	✓			
0.380	+/-0.010				N/A	See 09.10.07
0.200	+/-0.010	.200	✓			
0.600	+/-0.010	.600	✓			
0.780	+/-0.010	.784	✓			
0.500	+/-0.010	.500	✓			
0.063	+/-0.010	.062	✓			
R0.062	+/-0.010	R.063	✓			
0.162	+/-0.010	.160	✓			
Ø0.560	+0.008/-0.001	Ø.560	✓			
0.595	+/-0.010				N/A	See 09.10.07
4.21	+/-0.030	4.20	✓			
3.770	+/-0.010	3.77	✓			
1.280	+/-0.010	1.275	✓			
0.700	+/-0.010	.699	✓			
1.90	+/-0.030	1.89	✓			
100°	+/-0.5°	100°	✓			
2.14	+/-0.030	2.12	✓			
0.262	+/-0.010	.262	✓			
R0.25	+/-0.030	R.25	✓			
0.032	+/-0.010	.032	✓			

Measured by: <i>mw</i>	Audited by: <i>cmf</i>	Prototype Approval:	N/A
Date: 02/00/07	Date: 04/10/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D3137-045	KJ/JLM	
B	08.12.02	Dwg Rev updated	KJ/DD	<i>DD</i>

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

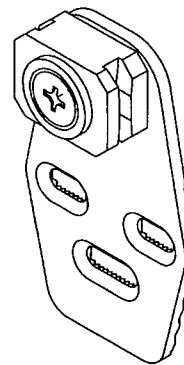
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WITHOUT NOTICE

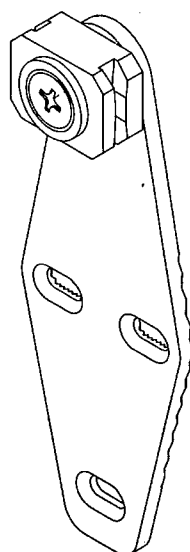
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NO. 52371

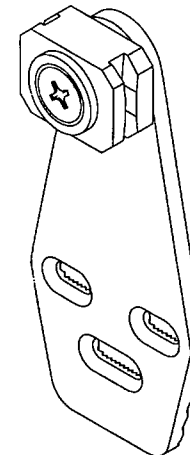
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D3137-041 BRACKET ASSEMBLY



D3137-043 BRACKET ASSEMBLY



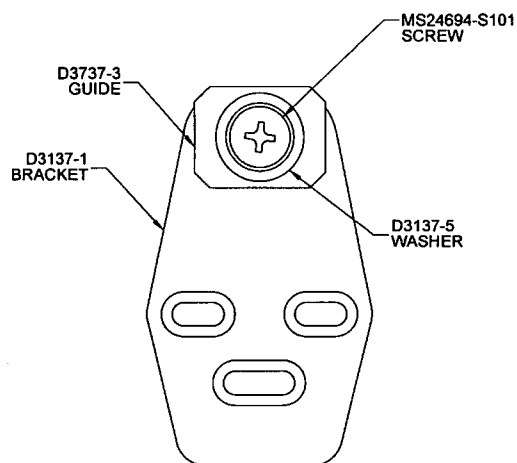
D3137-045 BRACKET ASSEMBLY

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26.06.2017

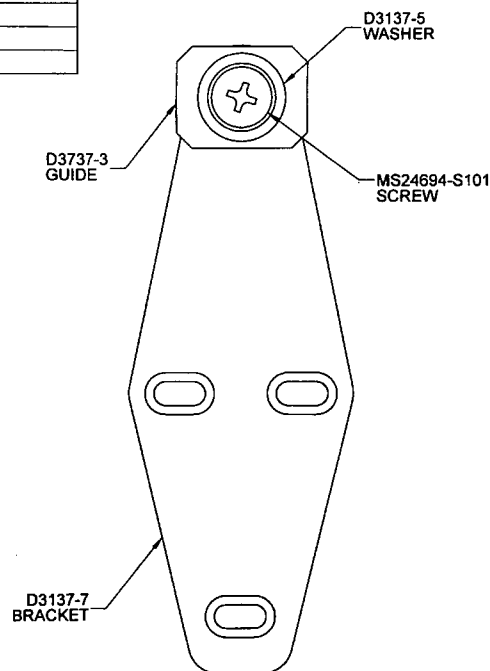
F	REDRAWN & REFORMATTED IN SOLIDWORKS. SHEET 3 ZONE A 5 DIM 2.38 WAS 2.48. ZONE A 4 0.480 DIM WAS 0.505. ZONE A 5 0.67 DIM WAS 0.75. ZONE B 5 4.850 DIM WAS 4.975 & ZONE B 8 5.29 DIM WAS 5.41. REASON: PART TRIMMED DUE TO INTERFERENCE WITH EXECUTIVE INTERIOR.	AJS	08.05.30
E	ADD -045	RF	05.11.23
D	RE-DESIGN D3137-5; CHANGE DIMS	DS	04.11.03
C	ADD -043	DS	03.08.15
B	ADD RIDGES; ADD MATERIAL PROP	DS	03.01.16
A	NEW ISSUE	DS	02.04.17
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3137	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET ASSEMBLY	NTS
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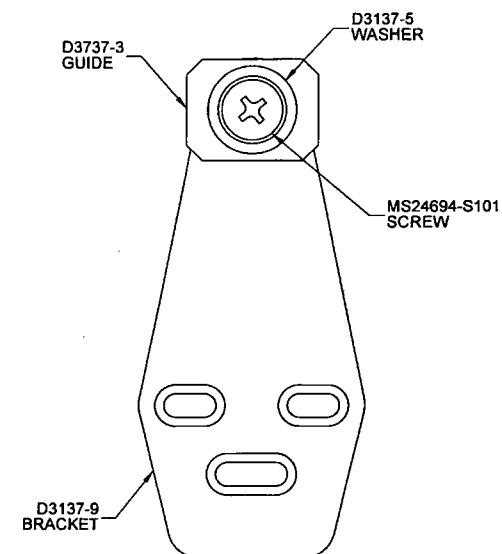
QTY. -041	QTY. -043	QTY. -045	PART NUMBER	DESCRIPTION
X			D3137-041	BRACKET ASSEMBLY
	X		D3137-043	BRACKET ASSEMBLY
		X	D3137-045	BRACKET ASSEMBLY
1			D3137-1	BRACKET
1	1	1	D3137-3	GUIDE
1	1	1	D3137-5	WASHER
	1		D3137-7	BRACKET
		1	D3137-9	BRACKET
1	1	1	MS24694-S101	SCREW



D3137-041 BRACKET ASSEMBLY



D3137-043 BRACKET ASSEMBLY



D3137-045 BRACKET ASSEMBLY

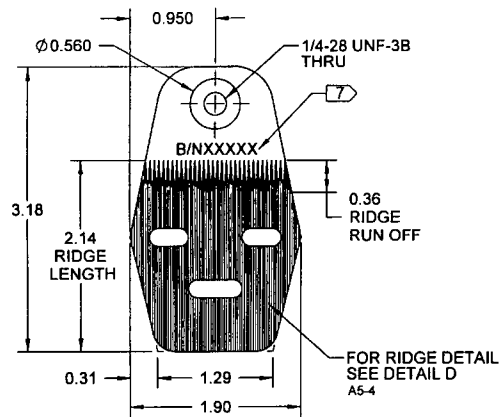
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.18 lbs -041
: 0.32 lbs -043
: 0.27 lbs -045

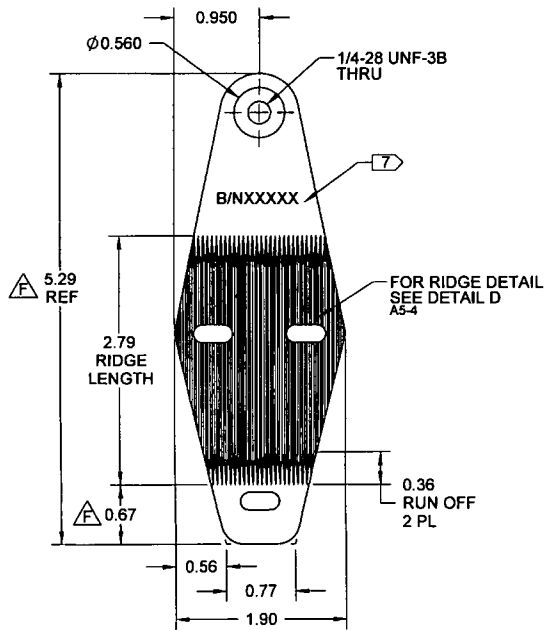
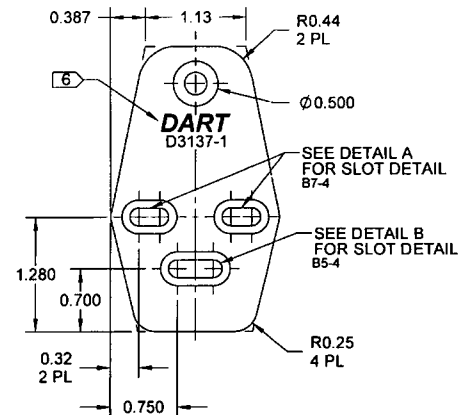
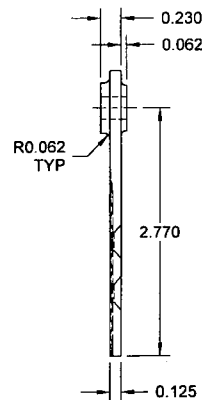
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08-06-26/10

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MFG. APPR.		D3137	SHEET 2 OF 5
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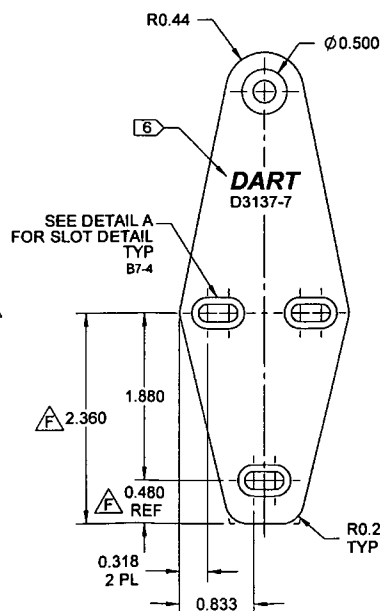
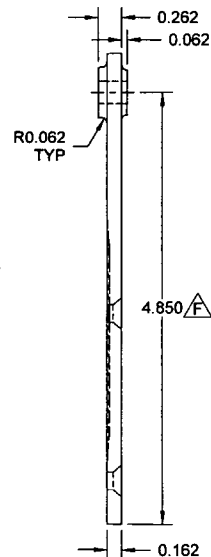
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D3137-1 BRACKET



D3137-7 BRACKET



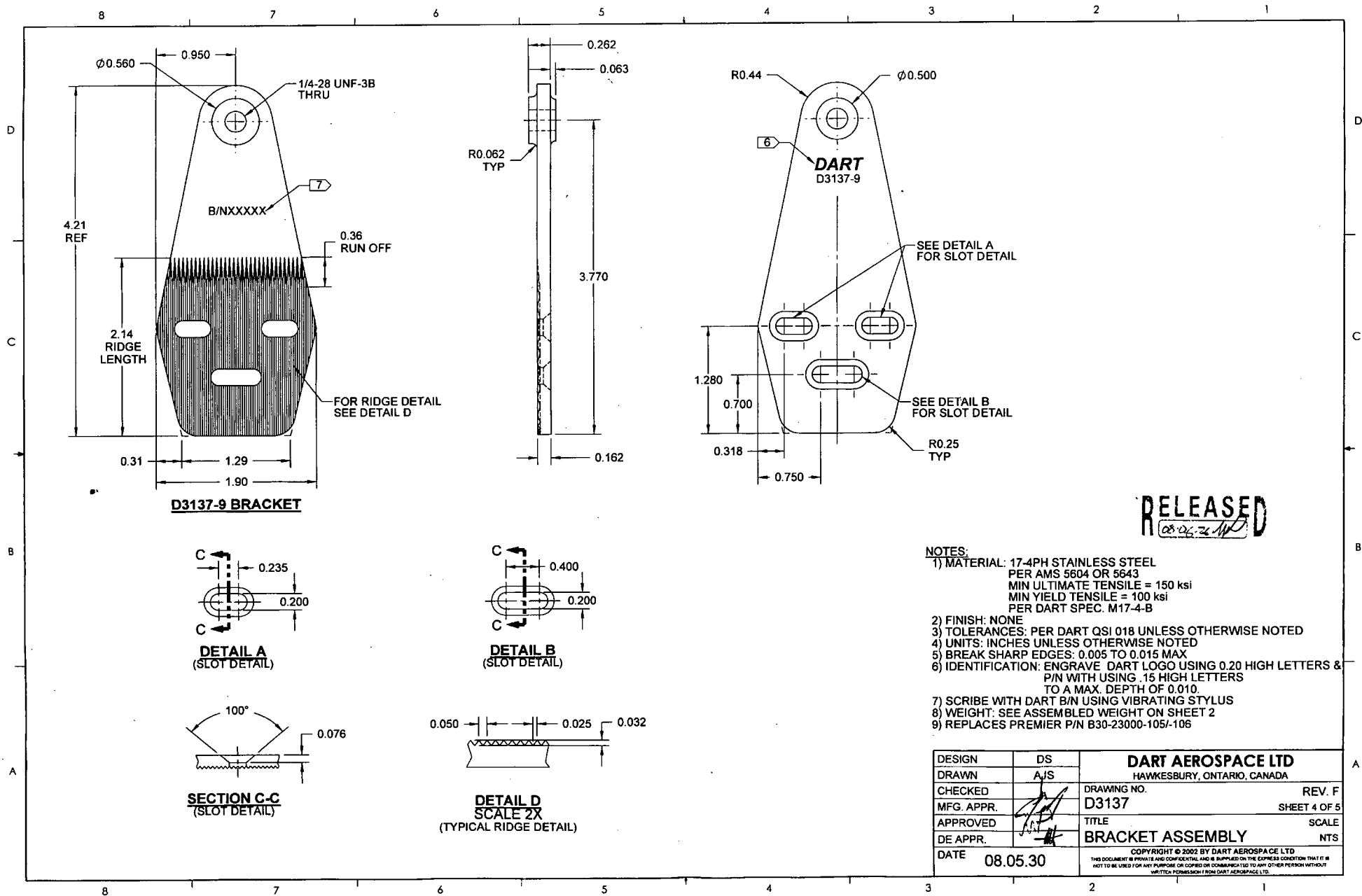
NOTES:

- 1) MATERIAL: -1 & -7
17-4PH STAINLESS STEEL
PER AMS 5604 OR 5643
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
PER DART SPEC. M17-4-B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: ENGRAVE DART LOGO USING 0.20 HIGH LETTERS & P/N WITH USING .15 HIGH LETTERS TO A MAX. DEPTH OF 0.010.
- 7) SCRIBE WITH DART B/N USING VIBRATING STYLUS
- 8) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 9) -1 REPLACES PREMIER P/N B30-23000-105/-1

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08-06-26 MJD

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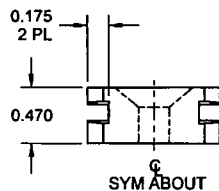
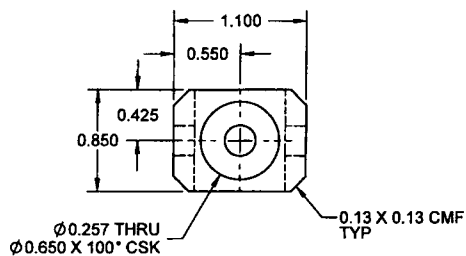
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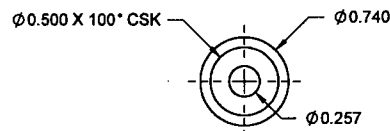
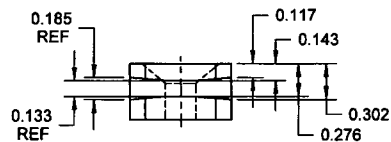
- NOTES:**
- 1) MATERIAL: 17-4PH STAINLESS STEEL
PER AMS 5604 OR 5643
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
PER DART SPEC. M17-4-B
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: ENGRAVE DART LOGO USING 0.20 HIGH LETTERS & P/N WITH USING .15 HIGH LETTERS TO A MAX. DEPTH OF 0.010.
 - 7) SCRIBE WITH DART B/N USING VIBRATING STYLUS
 - 8) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
 - 9) REPLACES PREMIER P/N B30-23000-105/-106

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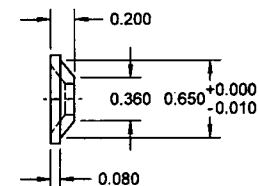
w/o 52371



D3137-3 GUIDE



D3137-5 WASHER



NOTES:

- 1) MATERIAL: -3
DELIN II 150E OR ACETRON GP ACETAL, BAR
(REF DART SPEC M-DELIN-B)
- 5
6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) ALUMINUM BAR
PER-AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4145/ 4116)
OR PER-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 (-5 ONLY)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 8) -3 REPLACES PREMIER P/N B30-2300-207
-5 REPLACES PREMIER P/N B30-2300-209

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2007.07.14

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